

Date: Monday, 18/08/2008 3:45:44 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER RESTRAINT WELDMENT
Job Number	: 41377		
Estimate Number	: 13398		
P.O. Number	:	Part Number	: PB674300131
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.41/ P.43
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 40064	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>JD 08-8-18</u>		
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.4557 sf(s)/Unit Total : 3.6456 sf(s)  
 6061-T6 .090 Sheet  
 batch: 108595 B 8-8-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg B67-43001-321  
 Dwg Rev: B1 B 8-8-21  
 Prog Rev: B1  
 \*\*\*grain direction along 25.00" \*\*\*  
 2-Deburr if necessary B 8-8-21

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/02 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Bend as per Dwg B67-43001

S 18/09/09 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: UPPER RESTRAINT WELDMENT

Job Number: 41377

Part Number: PB674300131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/10 SCQ

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-P 08/09/10

(10x)

8.0

POWDER COATING

POWDER COATING



M102316



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:50  
320 °F  
9:20

M-P 08/09/13

(10x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/8/10 (10)

10.0

PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Upper Pad Assembly

batch:

22998 B41505

CP 08/10/09

11.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch:

M10 8473

\* P

12.0

MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch:

107378

P 8/8/10 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 41377

Part Number: PB674300131

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Assemble as per dwg B67-43001

*EP 08/10/09 (10)*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/10/09 (11)*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 5T510

*JS 08/10/10 (10)*

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/10 JS*

Job Completion



*mf 08-10-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

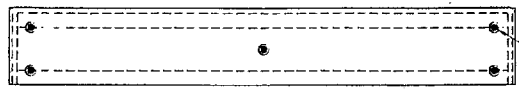
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

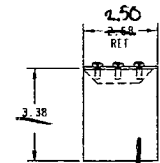
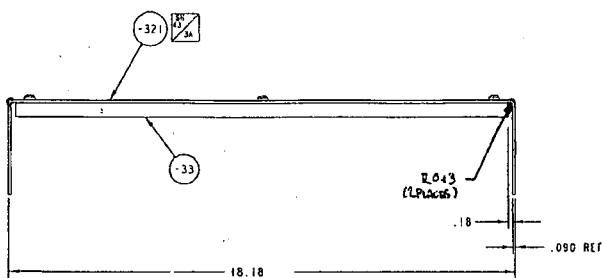
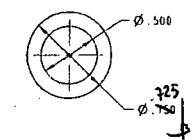
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
# 01-26

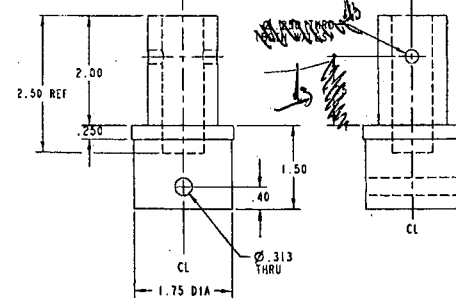
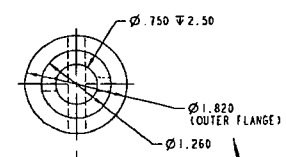
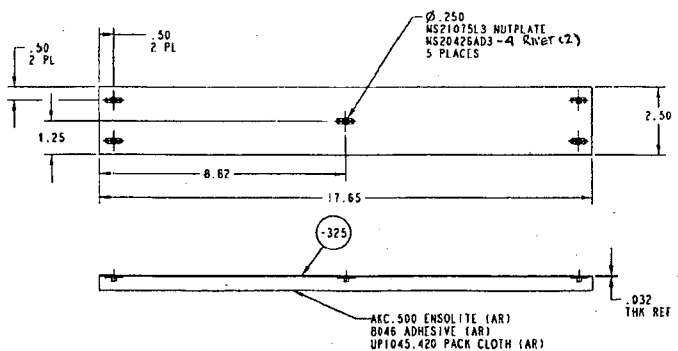


Ø .153 THRU  
MATCH DRILL WITH  
EXISTING NOTCH PLATE  
LOC'S OF -33  
MS27039-1-09 SCREW  
NAS114910316P WASHER  
5 PLACES



④ -299 BUSHING  
SCALE 2.000  
MAT: 304 CRES. COND A

① -31 UPPER RESTRAINT WELDMENT  
SCALE 0.500



① -33 UPPER PAD ASSY  
SCALE 0.500  
MATL FOR -325: .032 THK 2024-T3 AL.  
00-A-250/4

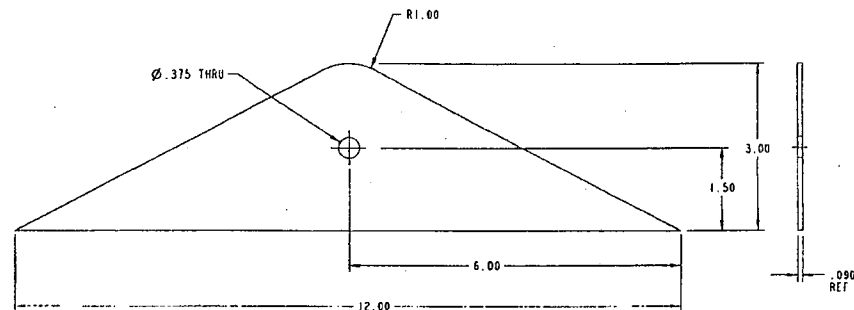
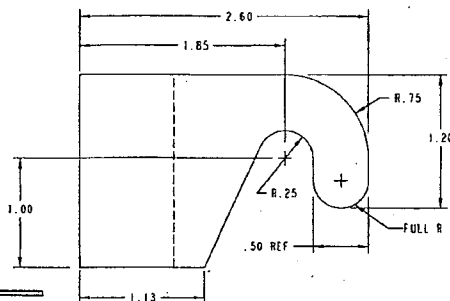
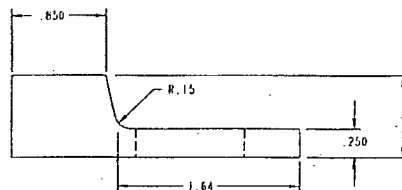
① -305 BEARING  
SCALE 1.000  
MAT: 2024-T3 AL.  
00-A-200/3

PREMIER AVIATION, INC.  
3001 Aviation Parkway, Grand Prairie, Texas 75052  
D/SUV8 B67-43001  
SCALE: 1:1 DRAWN: 45

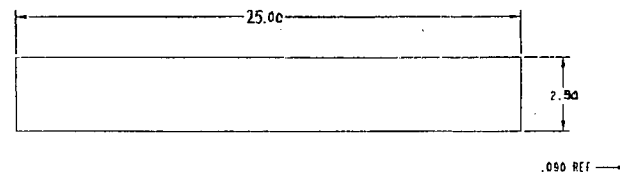
ORIGINAL

NO. 41327  
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SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

RELEASED  
26-01-20



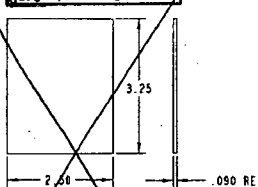
② -319 GUSSET  
SCALE 1.000  
MAT: .090 THK 6061-T6 AL.  
OO-A-200/B



① -321 PLATE  
SCALE 0.500  
MAT: .090 THK 6061-T6 AL.  
OO-A-200/B

SUPERCEDED BY

NEW PART OF -317



② -317 PLATE  
SCALE 0.750  
MAT: .090 THK 6061-T6 AL.  
OO-A-200/B

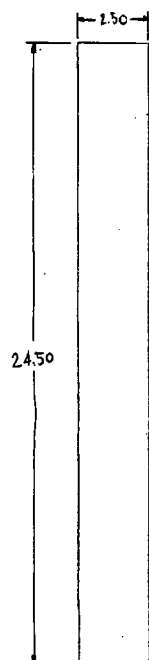
R0.13  
(2 PLACES)

③ -315 HOOK  
SCALE 2.000  
MAT: 6061-T6 AL.  
OO-A-200/B

-313 BENDWG  
DETAIL

-325  
(2 PLACES)

④



① -313 FLAT PATTERN  
SCALE 0.500  
MAT: .090 THK 6061-T6 AL.  
OO-A-200/B

PREMIER AVIATION, INC.			
8021 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	DEPT. NO.	QTY
D10SUV8		B67-43001	1
SCALE	BY	DATE	43 of 45

ORIGINAL

NO. 41377  
WORK ORDER  
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SHOP COPY



